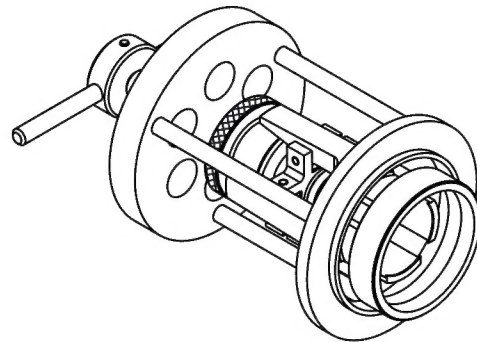
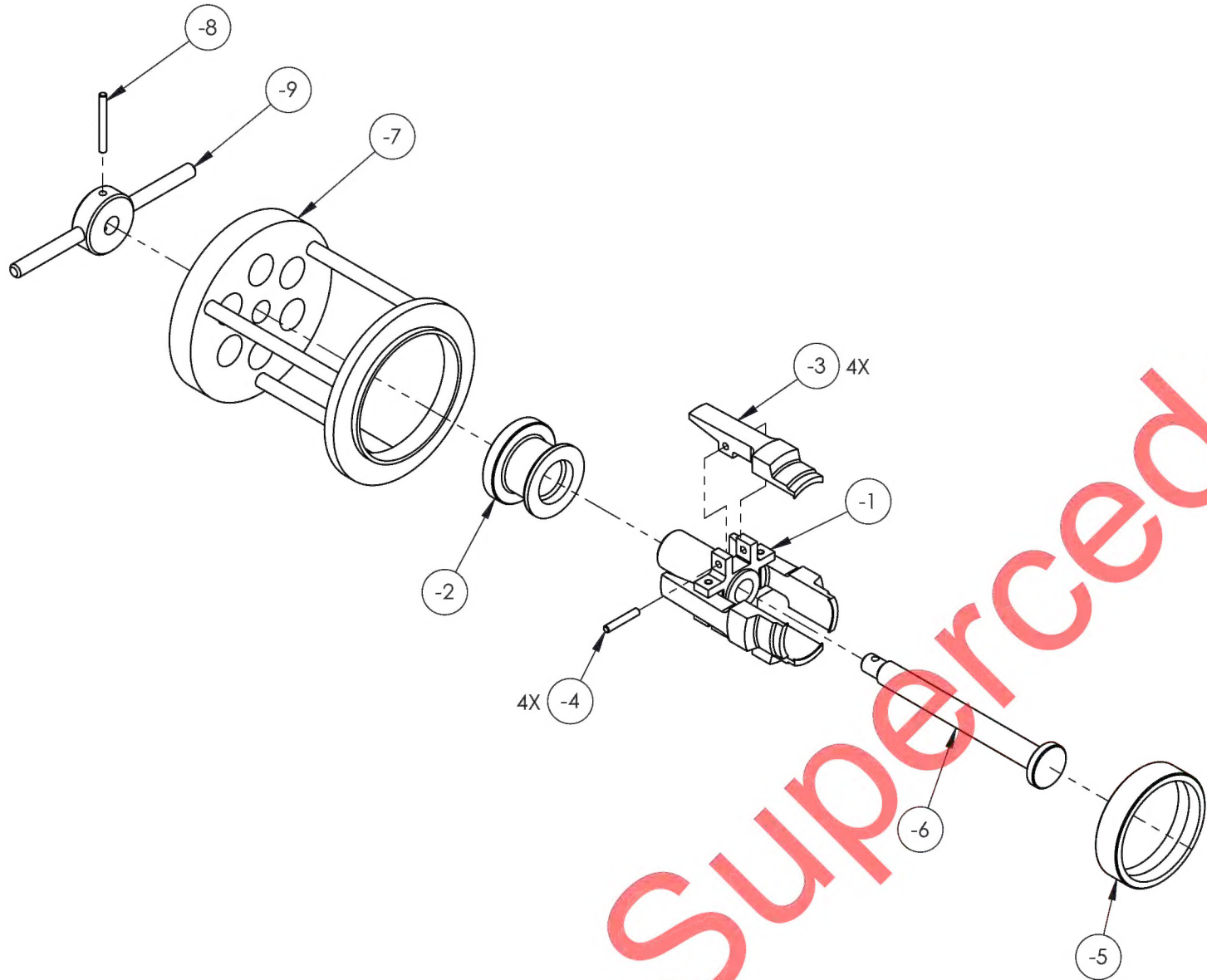


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UNDER REVIEW  
URF 19-755 19.05.30 (VM)

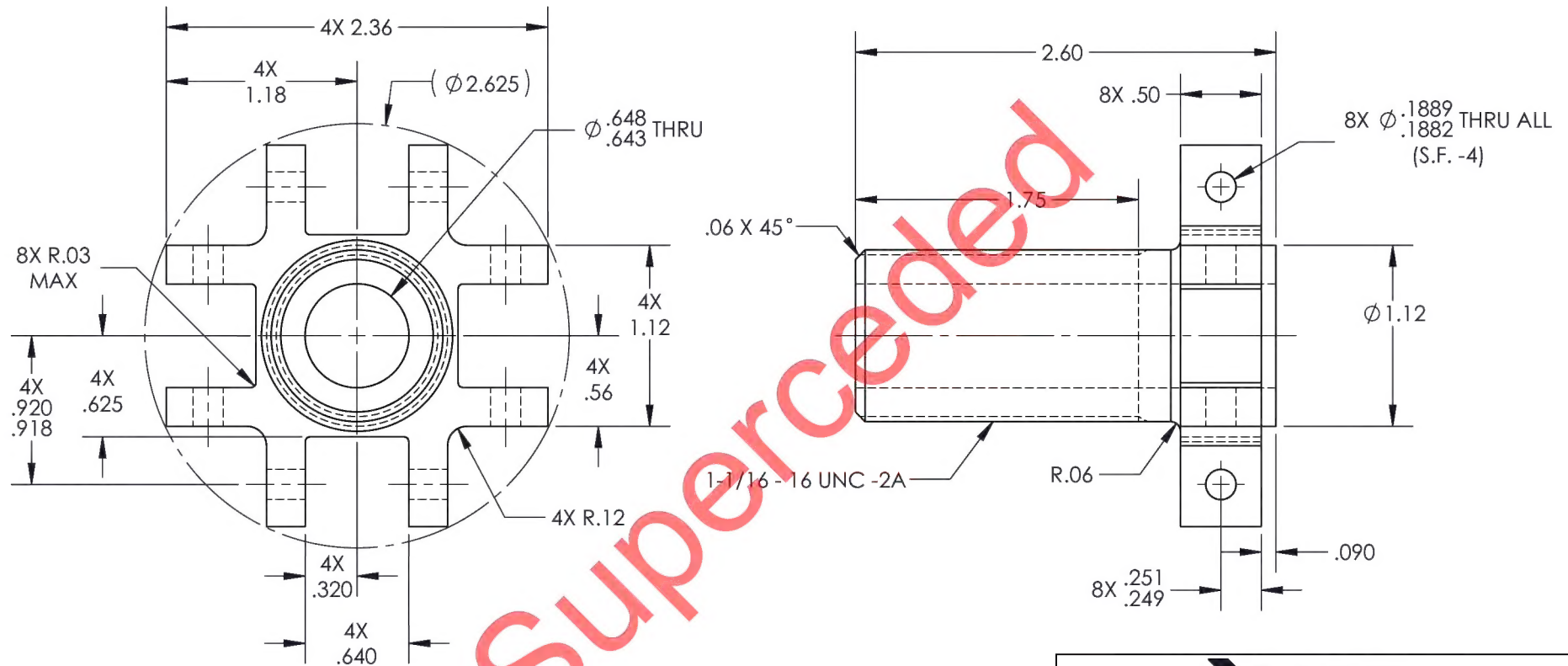
ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	ADJUSTING SCREW	4140/4142		2
			-2	1	ADJUSTING NUT	BRASS		3
			-3	4	FINGER	4140/4142		4
		B/O	-4	4	DOWEL PIN	STEEL	Ø3/16 X 1-1/8 (MCMaster-CARR# 98381A511)	1
			-5	1	RING	1018/1020 CR		5
			-6	1	JACK SCREW	4140/4142		6
	X		-7	1	BODY WELDMENT			7
	1		-7A		BODY BOTTOM	1018/1020 CR		8
	3		-7B		BODY COLUMN	1018/1020 CR		9
	1		-7C		BODY TOP	1018/1020 CR		10
		B/O	-8	1	DOWEL PIN	STEEL	Ø3/16 X 1-3/4 (MCMaster-CARR# 98381A515)	1
X			-9	1	HANDLE WELDMENT			11
2			-9A		HANDLE SPOKE	1018/1020 CR		12
1			-9B		HANDLE HUB	1018/1020 CR		13
ASSY -9	ASSY -7							

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		CHANGED -5 FROM INCLUDE ANGLE .750 TP PER FT. 0°53'37" TO .89°	-	-	-
2		ADDED -7 ASSEMBLY HEIGHT & TOL. CH'D -1; 3/16 S.F. PIN TO P.F.	1/02/07	WP	-
3		CHANGED TO NEW DWG. FORMAT, ORGANIZED DRAWINGS & ADDED ASSEMBLY VIEW.	7/18/08	WP	RW
3A		MOVED P/N -3 TO SHEET 5 OF 8. MOVED P/N -7A & -7B TO SHEET 7 OF 8. REDUCED SCALE P/N -7C. REARRANGED DWG., CH'D TOOL No. FROM 6872882.	4/28/09	RJC	-
4	15-0046	UPDATED TO NEW DRAFTING STANDARDS. REARRANGED DRAWINGS. -1 CH'D DIM WAS Ø.187 P.F. -4 IS Ø.1882-.1889 THRU S.F. -4. -3 CH'D DIM WAS Ø.191 THRU S.F. -4 IS Ø.1871-.1874 THRU P.F. -4, WAS 1"28" IS 1.78". ADD DIM 3X R.06. WAS 3.99 IS 3.93. WAS 2.625 IS 2.776. WAS LIM 2.057 TO 2.067 IS LIM 2.060 TO 2.062. WAS 0.880 IS 0.80 WAS 2.160 IS 2.180. WAS 1.508 IS 1.50. WAS 2.50 IS 2.625. DELETED DIM Ø1.445, 0.205. ADDED 0.470, 0.24. MOVED DIM LIM 2.598 - 2.600 TO INSIDE LIP. -4 ANGLE WAS 0.89° NOW 1.78°. ADDED DIMENTION 0.375. -6 CH'D DIMS WAS Ø.500 IS Ø.4995-.5000. WAS Ø.187 IS Ø.1871-.1874 THRU. -7A CH'D DIMS WAS Ø5.00 IS (Ø5.00). WAS 120° (X3) IS 2X 120°. WAS Ø.375 IS Ø.386. -7C CH'D NOTE WAS ENGRAVE P/N, S/N IS ENGRAVE T/N, S/N, CH'D DIMS WAS 120° (X3) IS 2X 120°. WAS 60° (X6) IS 5X 60°. WAS Ø.375 IS Ø.386. -9B CH'D DIMS WAS Ø.375 IS Ø.386, WAS Ø.188 THRU P.F. -8 IS Ø.1882-.1889 THRU ALL S.F. -8, WAS Ø.500 THRU IS Ø.5004-.5011 THRU.	2/26/2015	PMW	JAG
5	17-0110	-1, -3, -5, -6, -7, -9, 9A ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D. -5, -7A CH'D MATERIAL WAS 1018/1020 IS 1018/1020 CR. -1 CH'D DIM WAS 8X Ø.1889/.1882 THRU S.F. -4 IS 8X Ø.1889/.1882 THRU ALL (S.F. -4). -3 CH'D DIM WAS .312 IS .311. WAS Ø.1874/.1871 THRU P.F. -4 IS Ø.1874/.1871 THRU ALL (P.F. -4). -5 CH'D DIM WAS 2.765 IS Ø2.776. -6 CH' DIMS WAS Ø.1874/.1871 THRU P.F. -8 IS Ø.1874/.1871 THRU ALL (P.F. -8). WAS Ø.5000/.4995 S.F. -9B IS Ø.5000/.4995 (S.F. -9B). WAS .620 IS .62. DELETED DIM .310. ADDED DIM .310 +.010/-.000. -7 CH'D WELD CALLOUT WAS FAR SIDE IS NEAR SIDE. CH'D DATUM A TO CENTERLINE. DELETED CONCENTRIC CONTROL ON O.D. ADDED DIMS Ø3.709/3.704 CONCENTRIC Ø.01 TO DATUM A. .180. ADDED SURFACE FINISH 32 ON MACHINED SURFACES. -7A CH'D DIM WAS Ø3.709/3.704 IS Ø3.75. DELETED SURFACE FINISH 32 CALLOUTS. -7B, -7C, -7B CH'D MATERIAL WAS 1018 IS 1018/1020 CR. -7B CH'D DIM WAS Ø.375 IS Ø.38. -7C CH'D DIM WAS 6X Ø.87 THRU IS 6X Ø.87 THRU ALL. -9B CH'D DIMS WAS Ø.1889/.1882 THRU ALL S.F. -8 IS Ø.1889/.1882 THRU ALL (S.F. -8). WAS Ø.5011/.5004 THRU S.F. -6 IS Ø.5011/.5004 THRU ALL (S.F. -6). ADDED DIMS 2X .31, .310 +.010/-.000.	5/8/2017	RJC	JAG

<b>DART</b> AEROSPACE	
TITLE PULLER, TURBINE FRONT BEARING	
DWG NO. RB6872882	REV 5
MAT'L HEAT TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS ± 1/8 XXX ± .005 .XX ± .01 .X ± .1 ANGLES ± 5° SURFACES = 125/✓
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DD 05/09/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 05/10/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 05/24/2017	USED ON MODEL
APPROVED: JAG 06/02/2017	ALLISON 250 SERIES
SCALE 1:2	DATE 8/15/2007
SHEET 1 OF 13	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2		ADDED -7 ASSEMBLY HEIGHT & TOL, CHANGED -1: 3/16 S.F. PIN TO P.F.	1/02/07	WP	-
4	15-0046	CH'D DIM WAS Ø.187 P.F.	2/26/2015	PMW	JAG
5	17-0110	-1 CH'D DIM WAS 8X Ø.1889/.1882 THRU S.F. -4 IS 8X Ø.1889/.1882 THRU ALL (S.F. -4). ADDED FINISH SPEC QMSI-6.2.2, B.O., REV D.	5/8/2017	RJC	JAG



Superceded

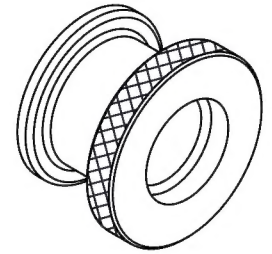
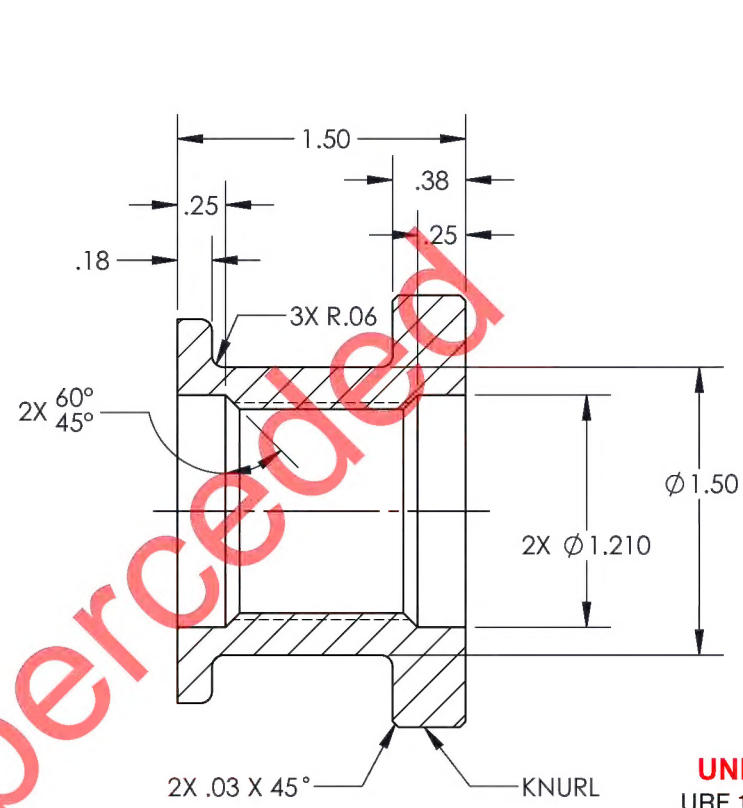
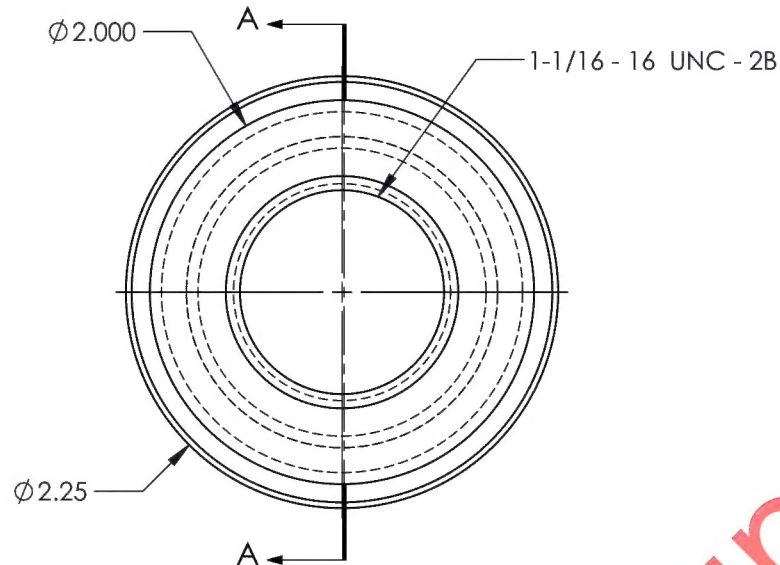
**UNDER REVIEW**  
URF 19-755 19.05.30 (VM)

(1)  
ADJUSTING SCREW

<b>DART AEROSPACE</b>	
TITLE <b>PULLER, TURBINE FRONT BEARING</b>	
DWG NO. <b>RB6872882-1</b>	REV <b>5</b>
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT RC 32-36	DIMENSIONS ARE IN INCHES
TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH BLACK OXIDE	.XX ± .01 ANGLES ± 5°
SPEC QMSI-6.2.2, B.O., REV D	.X ± .1 SURFACES = 125✓
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES
CHECKED: DD 05/09/2017	.015 x 45° OR .015R
OPPS APPR: AA 05/10/2017	2. DIMENSIONAL LIMITS APPLY
QA APPR: JL 05/24/2017	AFTER PLATING
APPROVED: JAG 06/02/2017	3. INTERPRET DIM AND TOL PER
SCALE 1:1	ASME Y14.5M-2009
DATE 5/18/2007	USED ON MODEL
SHEET 2 OF 13	ALLISON 250 SERIES

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



**UNDER REVIEW**  
URF 19-755 19.05.30 (VM)

SECTION A-A

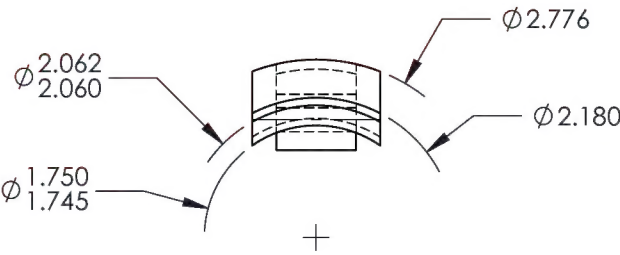
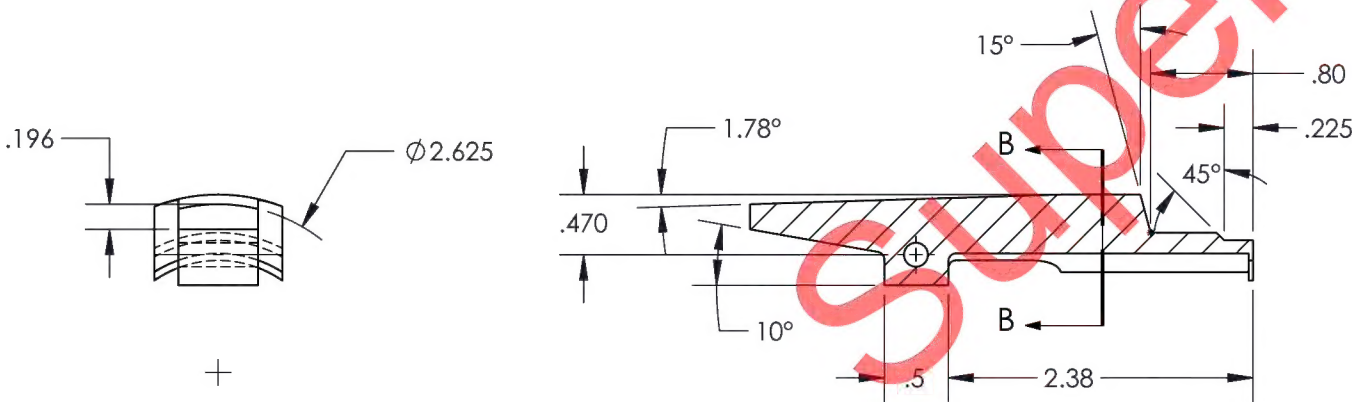
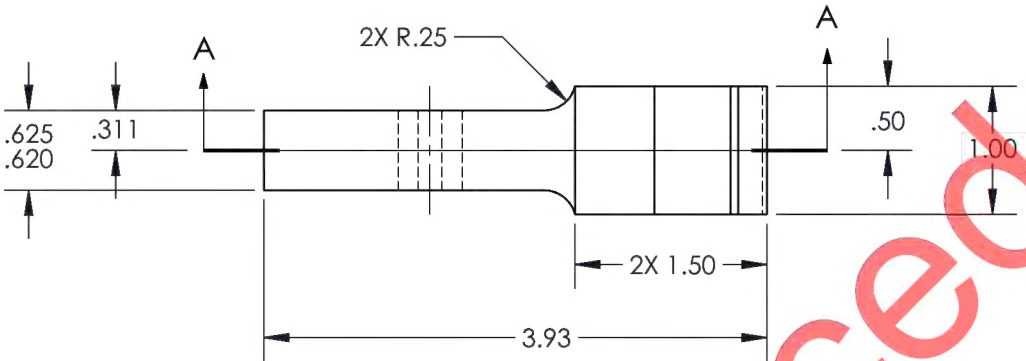
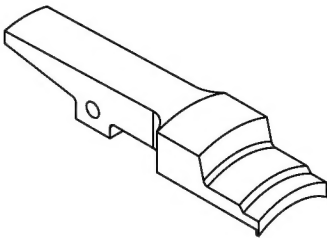
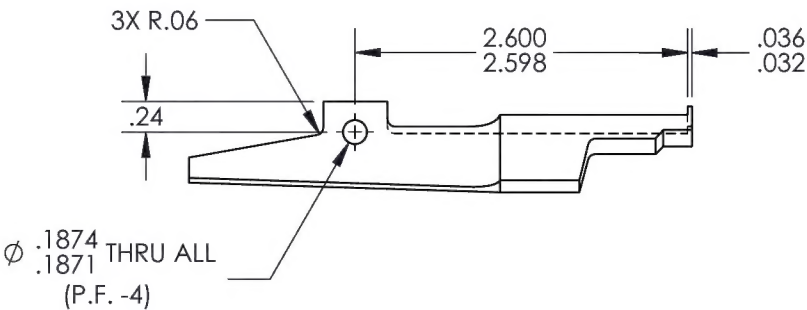
(-2)  
ADJUSTING NUT

<b>DART AEROSPACE</b>	
TITLE <b>PULLER, TURBINE FRONT BEARING</b>	
DWG NO. <b>RB6872882-2</b>	REV <b>5</b>
MAT'L BRASS	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125°
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES
CHECKED: DD 05/09/2017	.015 x 45° OR .015R
OPPS APPR: AA 05/10/2017	2. DIMENSIONAL LIMITS APPLY
QA APPR: JL 05/24/2017	AFTER PLATING
APPROVED: JAG 06/02/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:1	DATE 5/18/2007
	SHEET 3 OF 13

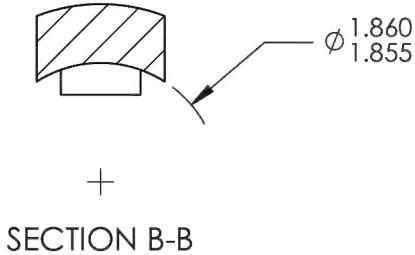


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3A		MOVED P/N -3 TO SHEET 5 OF 8. MOVED P/N -7A & -7B TO SHEET 7 OF 8. REDUCED SCALE P/N -7C, REARRANGED DWG., CH'D TOOL No. FROM 6872882.	4/28/09	RJC	-
4	15-0046	CH'D DIM WAS Ø.191 THRU S.F. -4 IS Ø.1871-.1874 THRU P.F. -4, WAS 1"28' IS 1.78", ADD DIM 3X R.06, WAS 3.99 IS 3.93, WAS 2.625 IS 2.776, WAS LIM 2.057 TO 2.067 IS LIM 2.060 TO 2.062, WAS 0.880 IS 0.80, WAS 2.160 IS 2.180, WAS 1.508 IS 1.50, WAS 2.50 IS 2.625. DELETED DIM Ø1.445, 0.205. ADDED 0.470, 0.24. MOVED DIM LIM 2.598 - 2.600 TO INSIDE LIP.	2/26/2015	PMW	JAG
5	17-0110	-3 CH'D DIM WAS .312 IS .311, WAS Ø.1874/.1871 THRU P.F. -4 IS Ø.1874/.1871 THRU ALL (P.F. -4), ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D.	5/8/2017	RJC	JAG



UNDER REVIEW  
URF 19-755 19.05.30 (VM)



SECTION A-A

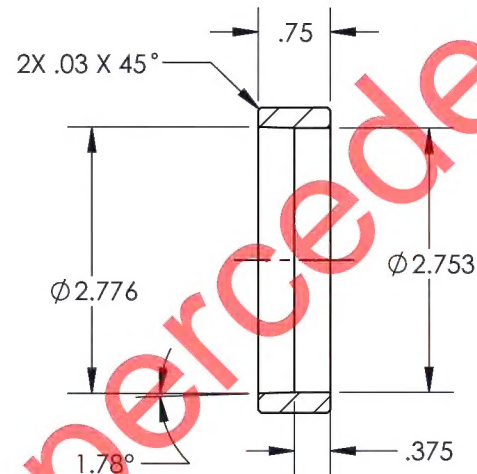
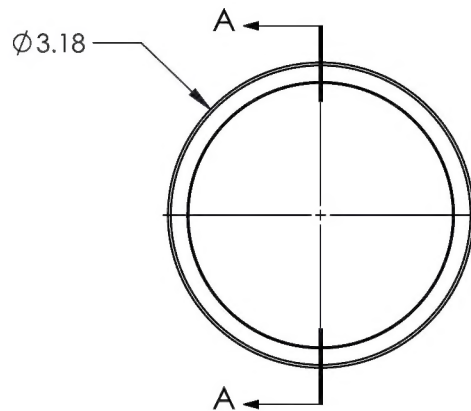
③

FINGER

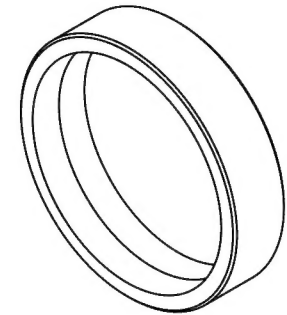
DART AEROSPACE			
TITLE PULLER, TURBINE FRONT BEARING			
DWG NO. RB6872882-3			REV 5
MAT'L 4140/4142		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT RC 36-40		DIMENSIONS ARE IN INCHES	
FINISH BLACK OXIDE		XXX ± .005 FRACTIONS ± 1/8	
SPEC QMSI-6.2.2, B.O. REV D		.XX ± .01 ANGLES ± 5°	
DRAWN BY: COLE		.X ± .1 SURFACES = 125	
CHECKED: DD 05/09/2017		1. BREAK ALL SHARP EDGES	
OPPS APPR: AA 05/10/2017		.015 x 45° OR .015R	
QA APPR: JL 05/24/2017		2. DIMENSIONAL LIMITS APPLY	
APPROVED: JAG 06/02/2017		AFTER PLATING	
SCALE 2:3		3. INTERPRET DIM AND TOL PER	
DATE 5/18/2007		ASME Y14.5M-2009	
SHEET 4 OF 13		USED ON MODEL	
		ALLISON 250 SERIES	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		CHANGED -5 FROM INCLUDE ANGLE .750 TP PER FT. 0°53'37" TO .89°	-	-	-
4	15-0046	ANGLE WAS 0.89° NOW 1.78°. ADDED DIMENTION 0.375.	6/29/2015	SM	JAG
5	17-0110	-5 CH'D DIM WAS 2.765 IS Ø2.776. CH'D MATERIAL WAS 1018/1020 IS 1018/1020 CR. ADDED FINISH SPEC QMSI-6.2.2, B.O, REV D.	5/8/2017	RJC	JAG



SECTION A-A



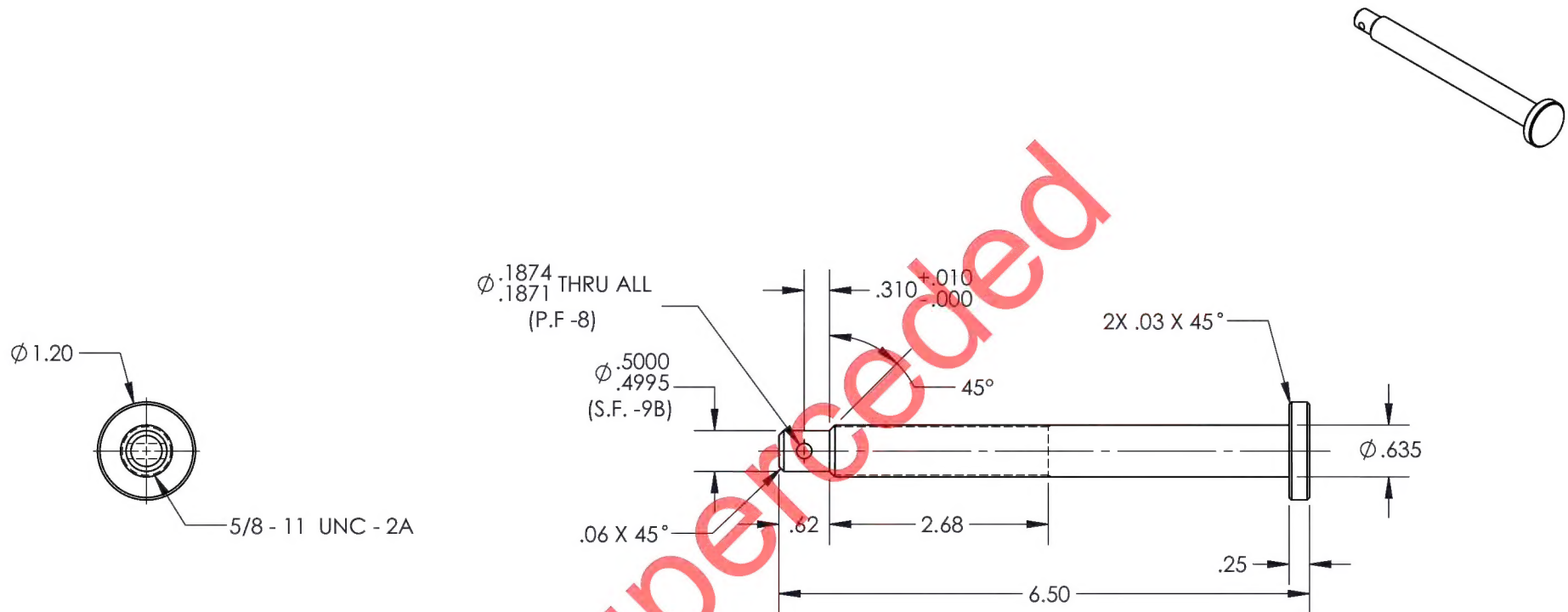
**UNDER REVIEW**  
URF 19-755 19.05.30 (VM)

(-5)  
RING

<b>DART AEROSPACE</b>	
TITLE <b>PULLER, TURBINE FRONT BEARING</b>	
DWG NO. <b>RB6872882-5</b>	REV <b>5</b>
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX ± .005 FRACTIONS ± 1/8
SPEC QMSI-6.2.2, B.O. REV D	.XX ± .01 ANGLES ± .5°
DRAWN BY: COLE	.X ± .1 SURFACES = 125° ✓
CHECKED: DD 05/09/2017	1. BREAK ALL SHARP EDGES
OPPS APPR: AA 05/10/2017	2. DIMENSIONAL LIMITS APPLY
QA APPR: JL 05/24/2017	AFTER PLATING
APPROVED: JAG 06/02/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:2	DATE 5/18/2007
SHEET 5 OF 13	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
4	15-0046	CH'D DIMS WAS Ø.500 IS Ø.4995-.5000, WAS Ø.187 IS Ø.1871-.1874 THRU.	2/26/2015	PMW	JAG
5	17-0110	-6 CH' DIMS WAS Ø.1874/.1871 THRU P.F. -8 IS Ø.1874/.1871 THRU ALL (P.F. -8). WAS Ø.5000/.4995 S.F. -9B IS Ø.5000/.4995 (S.F. -9B). WAS .620 IS .62. DELETED DIM .310. ADDED DIM .310 +.010/-.000. ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D.	5/8/2017	RJC	JAG



**UNDER REVIEW**  
URF 19-755 19.05.30 (VM)

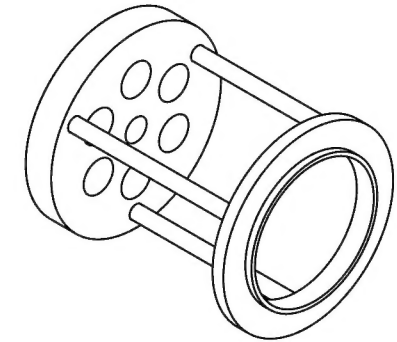
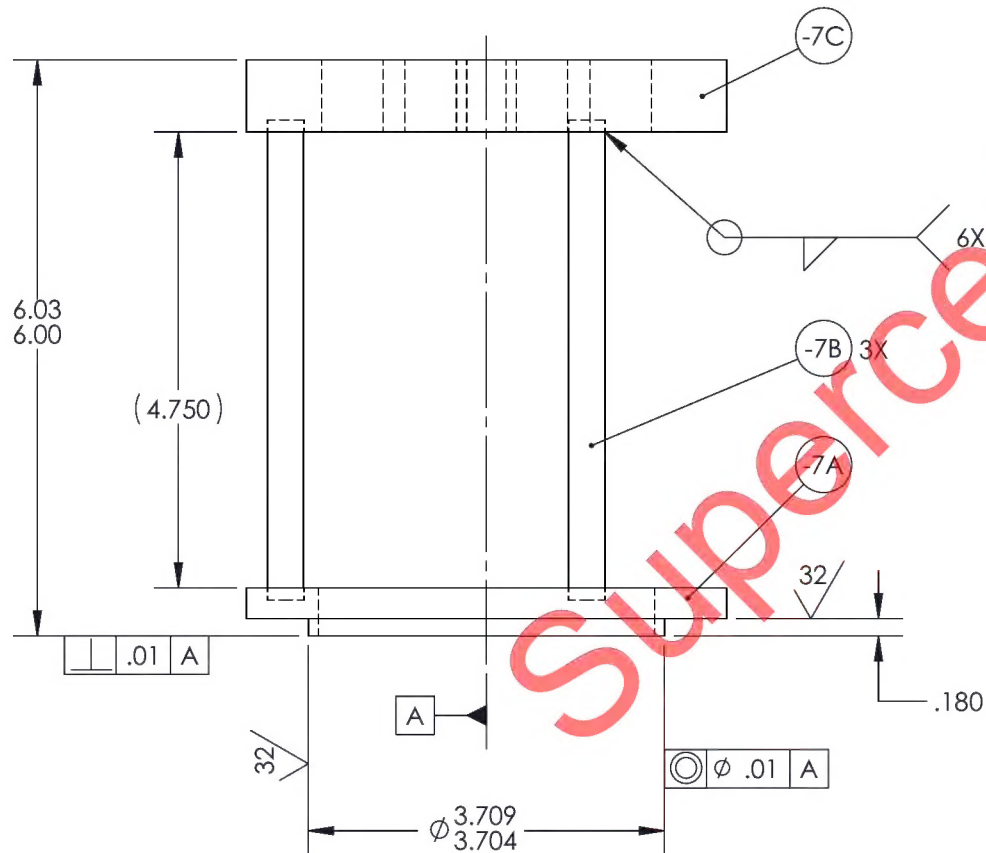
(-6)

JACK SCREW

<b>DART AEROSPACE</b>	
TITLE <b>PULLER, TURBINE FRONT BEARING</b>	
DWG NO. <b>RB6872882-6</b>	REV <b>5</b>
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT 36-40	DIMENSIONS ARE IN INCHES
TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH BLACK OXIDE	.XX ± .01 ANGLES ± 5°
SPEC QMSI-6.2.2, B.O. REV D	.X ± .1 SURFACES = 125° ✓
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES
CHECKED: DD 05/09/2017	.015 x 45° OR .015R
OPPS APPR: AA 05/10/2017	2. DIMENSIONAL LIMITS APPLY
QA APPR: JL 05/24/2017	AFTER PLATING
APPROVED: JAG 06/02/2017	3. INTERPRET DIM AND TOL PER
SCALE 1:2	ASME Y14.5M-2009
DATE 5/18/2007	USED ON MODEL
SHEET 6 OF 13	ALLISON 250 SERIES

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2		ADDED -7 ASSEMBLY HEIGHT & TOL, CHANGED -1: 3/16 S.F. PIN TO P.F.	1/02/07	WP	-
5	17-0110	-7 CH'D WELD CALLOUT WAS FAR SIDE IS NEAR SIDE, CH'D DATUM A TO CENTERLINE, DELETED CONCENTRIC CONTROL ON O.D. ADDED DIMS Ø3.709/3.704 CONCENTRIC Ø.01 TO DATUM A, .180. ADDED SURFACE FINISH 32 ON MACHINED SURFACES, ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D.	5/8/2017	RJC	JAG



**UNDER REVIEW**  
URF 19-755 19.05.30 (VM)

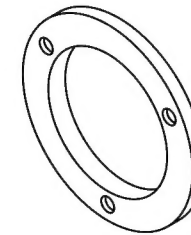
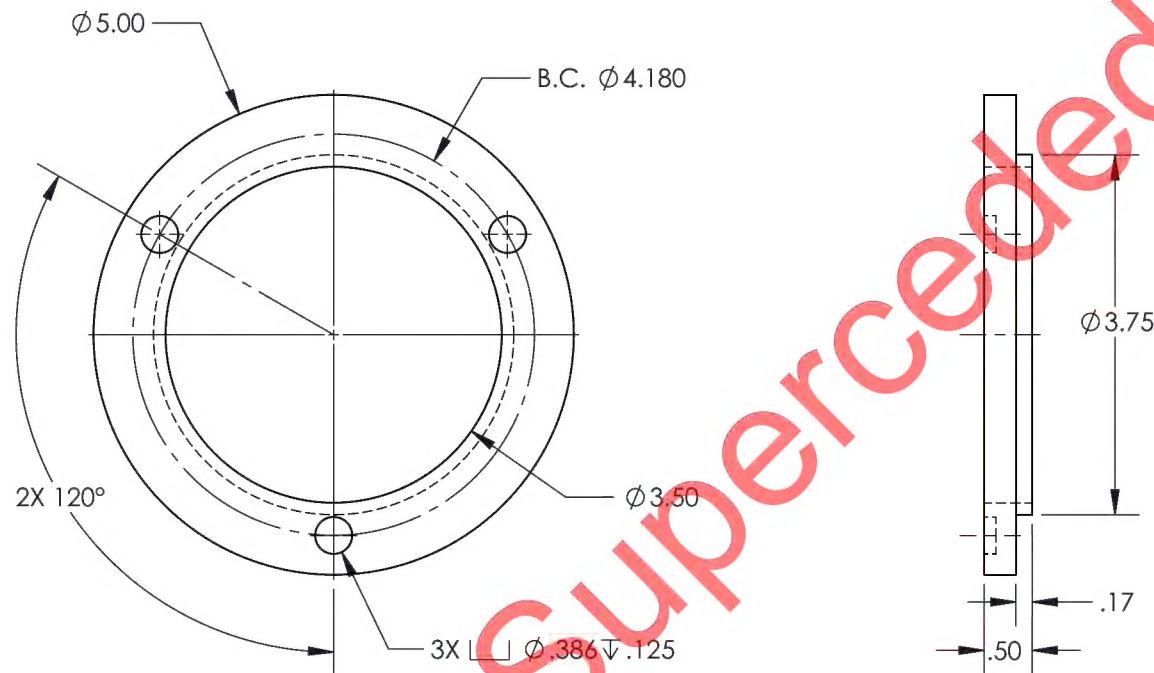
<b>DART AEROSPACE</b>	
TITLE <b>PULLER, TURBINE FRONT BEARING</b>	
DWG NO. <b>RB6872882-7</b>	REV <b>5</b>
MAT'L HEAT TREAT FINISH BLACK OXIDE SPEC QMSI-6.2.2, B.O. REV D	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125/✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: COLE CHECKED: DD 05/09/2017 OPPTS APPR: AA 05/10/2017 QA APPR: JL 05/24/2017 APPROVED: JAG 06/02/2017	
USED ON MODEL ALLISON 250 SERIES	
SCALE 1:2	DATE 5/18/2007
SHEET 7 OF 13	

(-7)  
BODY WELDMENT



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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3A		MOVED P/N -3 TO NEW SHEET 5 OF 8. MOVED P/N -7A & -7B TO NEW SHEET 7 OF 8. REDUCED SCALE P/N -7C, REARRANGED DWG., CH'D TOOL No. FROM 6872882.	4/28/09	RJC	-
4	15-0046	CH'D DIMS WAS Ø5.00 IS Ø5.00. WAS 120° (X3) IS 2X 120°, WAS Ø.375 IS Ø.386.	2/26/2015	PMW	JAG
5	17-0110	-7A CH'D DIM WAS Ø3.709/3.704 IS Ø3.75. DELETED SURFACE FINISH 32 CALLOUTS. CH'D MATERIAL WAS 1018/1020 IS 1018/1020 CR.	5/8/2017	RJC	JAG



**UNDER REVIEW**  
URF 19-755 19.05.30 (VM)

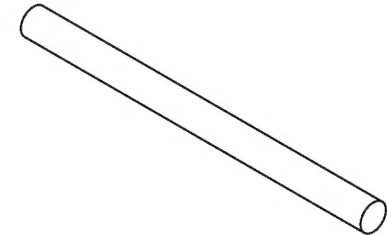
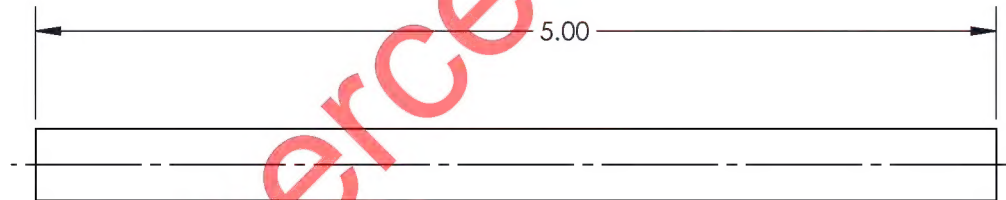
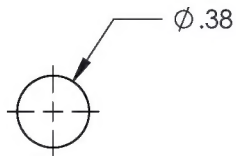
(-7A)  
BODY BOTTOM

<b>DART AEROSPACE</b>	
TITLE <b>PULLER, TURBINE FRONT BEARING</b>	
DWG NO. <b>RB6872882-7A</b>	REV <b>5</b>
MAT'L 1018/1020 CR FINISH SEE -7 WELDMENT SPEC DRAWN BY: COLE CHECKED: DD 05/09/2017 OPPTS APPR: AA 05/10/2017 QA APPR: JL 05/24/2017 APPROVED: JAG 06/02/2017	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125° 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
USED ON MODEL ALLISON 250 SERIES	
SCALE 1:2	DATE 5/18/2007
SHEET 8 OF 13	



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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3A		MOVED P/N -3 TO NEW SHEET 5 OF 8. MOVED P/N -7A & -7B TO NEW SHEET 7 OF 8. REDUCED SCALE P/N -7C, REARRANGED DWG., CH'D TOOL No. FROM 6872882.	4/28/09	RJC	
5	17-0110	-7B CH'D DIM WAS Ø.375 IS Ø.38. CH'D MATERIAL WAS 1018 IS 1018/1020 CR.	5/8/2017	RJC	JAG



Superceded

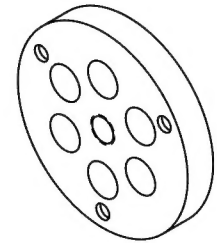
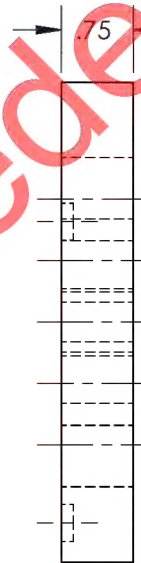
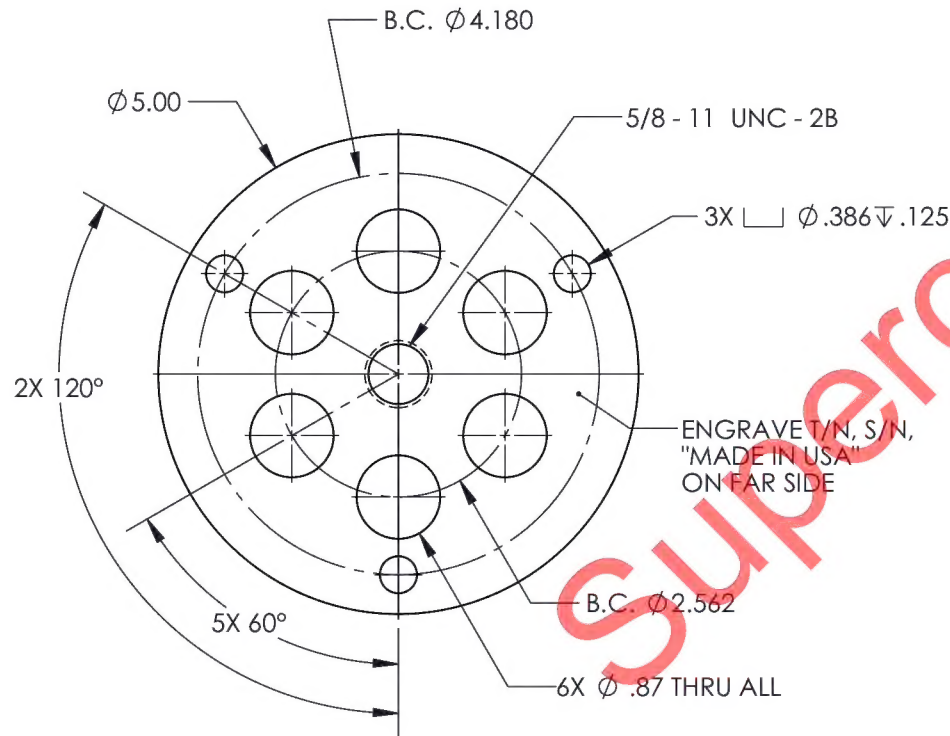
**UNDER REVIEW**  
URF 19-755 19.05.30 (VM)

(-7B)  
BODY COLUMN

<b>DART AEROSPACE</b>	
TITLE <b>PULLER, TURBINE FRONT BEARING</b>	
DWG NO. <b>RB6872882-7B</b>	REV <b>5</b>
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -7 WELDMENT	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES
CHECKED: DD 05/09/2017	.015 x 45° OR .015R
OPPS APPR: AA 05/10/2017	2. DIMENSIONAL LIMITS APPLY
QA APPR: JL 05/24/2017	AFTER PLATING
APPROVED: JAG 06/02/2017	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:1	DATE 5/18/2007
	SHEET 9 OF 13

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3A		MOVED P/N -3 TO NEW SHEET 5 OF 8. MOVED P/N -7A & -7B TO NEW SHEET 7 OF 8. REDUCED SCALE P/N -7C, REARRANGED DWG., CH'D TOOL No. FROM 6872882.	4/28/09	RJC	-
4	15-0046	CH'D NOTE WAS ENGRAVE P/N, S/N IS ENGRAVE T/N, S/N. CH'D DIMS WAS 120° (X3) IS 2X 120°. WAS 60° (X6) IS 5X 60°. WAS Ø.375 IS Ø.386.	2/26/2015	PMW	JAG
5	17-0110	-7C CH'D DIM WAS 6X Ø.87 THRU IS 6X Ø.87 THRU ALL. CH'D MATERIAL WAS 1018 IS 1018/1020 CR.	5/8/2017	RJC	JAG



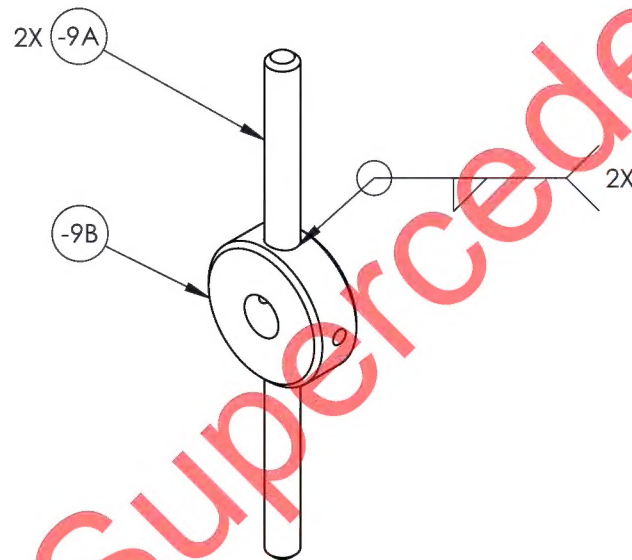
**UNDER REVIEW**  
URF 19-755 19.05.30 (VM)

(-7C)  
BODY TOP

<b>DART AEROSPACE</b>	
TITLE <b>PULLER, TURBINE FRONT BEARING</b>	
DWG NO. <b>RB6872882-7C</b>	REV <b>5</b>
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -7 WELDMENT	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125°
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES
CHECKED: DD 05/09/2017	.015 x 45° OR .015R
OPPS APPR: AA 05/10/2017	2. DIMENSIONAL LIMITS APPLY
QA APPR: JL 05/24/2017	AFTER PLATING
APPROVED: JAG 06/02/2017	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:2	DATE 5/18/2007
	SHEET 10 OF 13

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
5	17-0110	-9 ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D.	5/8/2017	RJC	JAG



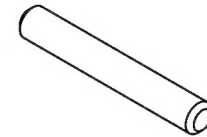
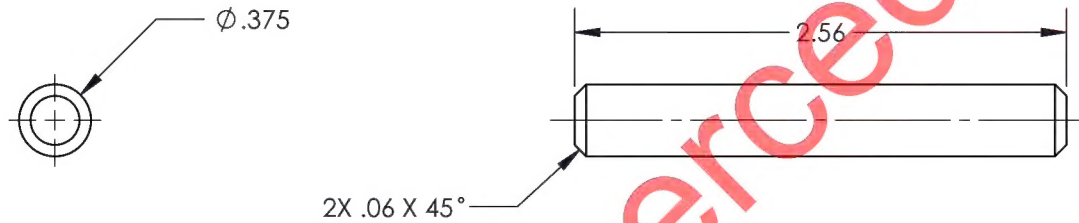
**UNDER REVIEW**  
URF 19-755 19.05.30 (VM)

(-9)  
HANDLE WELDMENT

<b>DART AEROSPACE</b>	
TITLE <b>PULLER, TURBINE FRONT BEARING</b>	
DWG NO. <b>RB6872882-9</b>	REV <b>5</b>
MAT'L <b>ASTM B633 TYPE I SC 2</b>	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT <b>BLACK OXIDE</b>	.XXX ± .005 FRACTIONS ± 1/8
FINISH <b>BLACK OXIDE</b>	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125°
DRAWN BY: <b>COLE</b>	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: <b>DD 05/09/2017</b>	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: <b>AA 05/10/2017</b>	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: <b>JL 05/24/2017</b>	USED ON MODEL
APPROVED: <b>JAG 06/02/2017</b>	ALLISON 250 SERIES
SCALE <b>1:2</b>	DATE <b>5/18/2007</b>
SHEET 11 OF 13	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
5	17-0110	-9A ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D.	5/8/2017	RJC	JAG



Superseded

**UNDER REVIEW**  
URF 19-755 19.05.30 (VM)

(-9A)

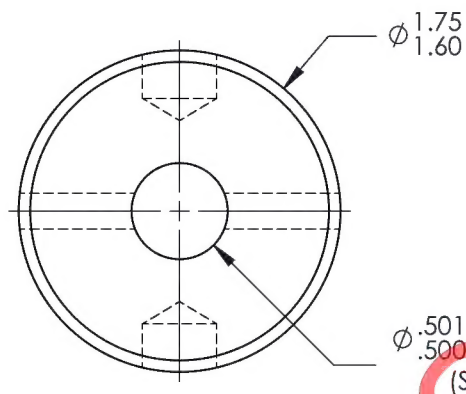
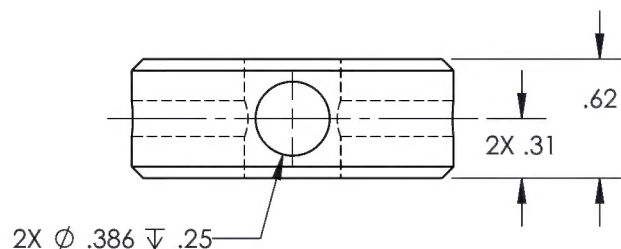
HANDLE SPOKE

<b>DART AEROSPACE</b>	
TITLE <b>PULLER, TURBINE FRONT BEARING</b>	
DWG NO. <b>RB6872882-9A</b>	REV <b>5</b>
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE-9 WELDMENT	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES
CHECKED: DD 05/09/2017	.015 x 45° OR .015R
OPPS APPR: AA 05/10/2017	2. DIMENSIONAL LIMITS APPLY
QA APPR: JL 05/24/2017	AFTER PLATING
APPROVED: JAG 06/02/2017	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:1	DATE 8/15/2007
	SHEET 12 OF 13

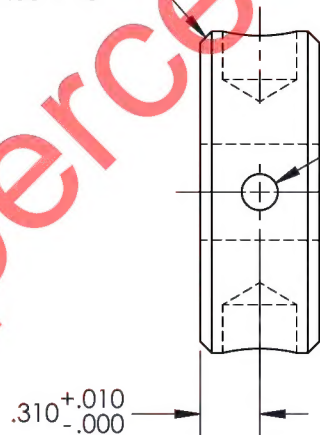


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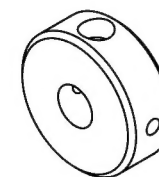
REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
4	15-0046	CH'D DIMS WAS Ø.375 TO Ø.386, WAS Ø.188 THRU P.F. -8 IS Ø.1882-.1889 THRU ALL S.F. -8, WAS Ø.500 THRU IS Ø.5004-.5011 THRU.	2/26/2015	PMW	JAG
5	17-0110	-9B CH'D DIMS WAS Ø.1889/.1882 THRU ALL S.F. -8 IS Ø.1889/.1882 THRU ALL (S.F. -8), WAS Ø.5011/.5004 THRU S.F. -6 IS Ø.5011/.5004 THRU ALL (S.F. -6). ADDED DIMS 2X .31, .310 +.010/.000. CH'D MATERIAL WAS 1018 IS 1018/1020 CR.	5/8/2017	RJC	JAG



2X .06 X 45°



Ø .1889  
Ø .1882 THRU ALL  
(S.F. -8)



**UNDER REVIEW**  
URF 19-755 19.05.30 (VM)

(-9B)

HANDLE HUB

<b>DART AEROSPACE</b>	
TITLE <b>PULLER, TURBINE FRONT BEARING</b>	
DWG NO. <b>RB6872882-9B</b>	REV <b>5</b>
MAT'L 1018/1020 CR	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
FEAT TREAT FINISH SPEC	.XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: CHECKED: OPPS APPR: QA APPR: APPROVED:	RJC 05/08/2017 DD 05/09/2017 AA 05/10/2017 JL 05/24/2017 JAG 06/02/2017
USED ON MODEL ALLISON 250 SERIES	
SCALE 1:1	DATE 5/8/2017
SHEET 13 OF 13	